

Shg Oct 15

Date:
User:

Friday, 9/21/2007 1:00:02 PM
Kim Johnston

Process Sheet

split
del 10
03/07/10/15

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 34784-1
Estimate Number : 12887
P.O. Number : N/A
This Issue : 9/21/2007 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : SMALL /MED FAB
Previous Run : 32189
Written By :
Checked & Approved By :
Comment : Est Rev. New Issue 07-05-28 EC

Drawing Name : GPS RECEIVER HOUSING

Part Number : D3514043
Drawing Number : UNDER REVIEW D3514
Project Number : N/A
Drawing Revision : W A 02/09/24 E
Material : N/A
Due Date : 10/15/2007 Qty: 5 Um: Eac

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D3514047 TOP MOUNTED HOUSING ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
TOP MOUNTED HOUSING ASSEMBLY B 34800

2.0 D35221 GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
GASKET
Batch: B 34801

3.0 D35231 LEG



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
LEG
Batch: B 34802 B 35168

4.0 D35241 LOWER PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
LOWER PLATE
Batch: B 34803

5.0 D3531041 BRACKET ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
BRACKET ASSEMBLY
Batch: B 34804

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07/10/15	15	Split w/o	JB	07/10/15	1			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GPS RECEIVER HOUSING

Job Number: 34784

Part Number: D3514043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D35333

Set Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Set Screw

Batch: B28093 B34898*EC*

7.0

AN36A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bolt

Batch: M100184*EC*

8.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Washer

Batch: M103044*EC*

9.0

MS24693S29

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Screw

Batch: M103915*EC*

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D3514

MF

07-10-26

07-10-15

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

EC 07-10-26

12.0

PACKAGING 1

PACKAGING RESOURCE #1

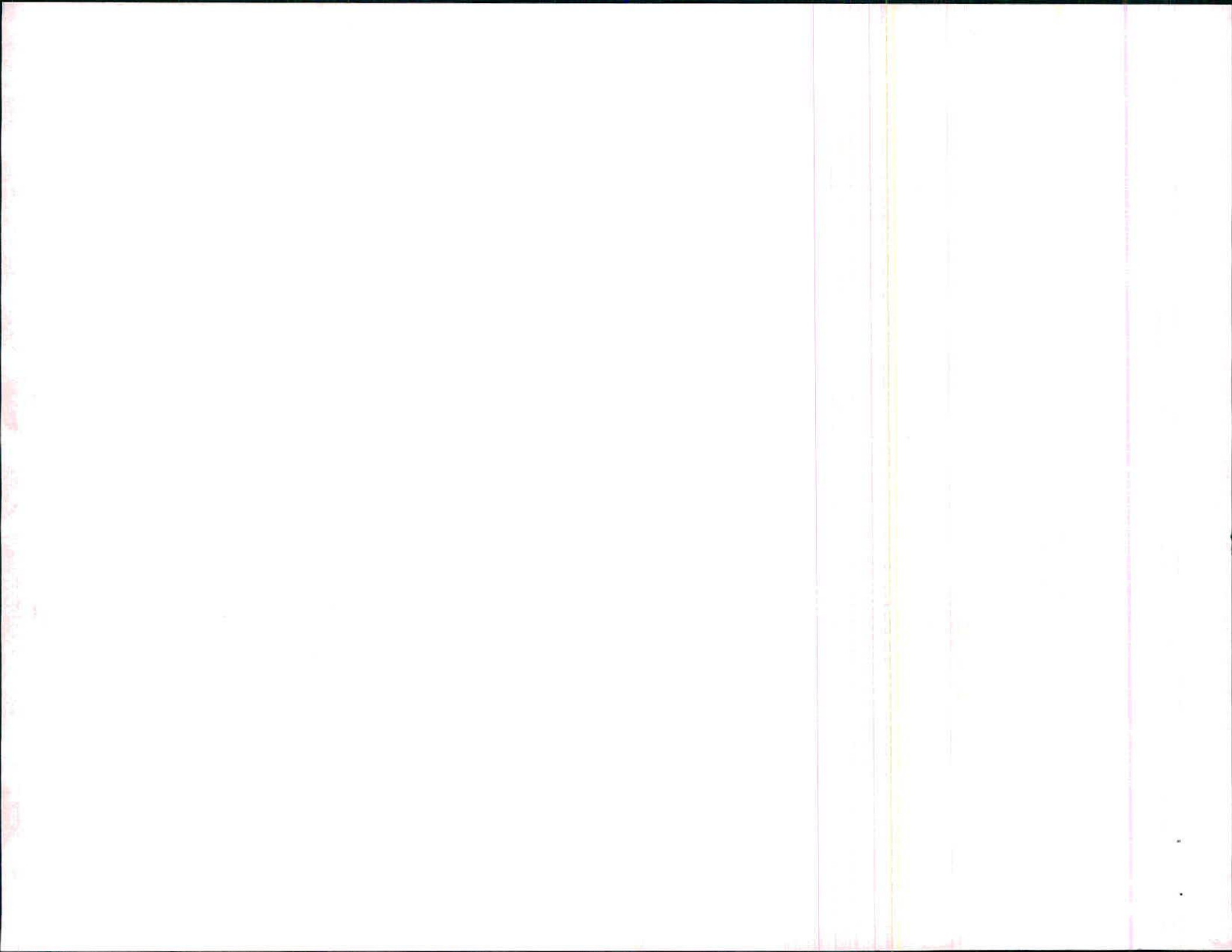


Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

EC 07-10-26



Friday, 9/21/2007 1:00:02 PM
Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GPS RECEIVER HOUSING

Job Number: 34784

Part Number: D3514043

Job Number;



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



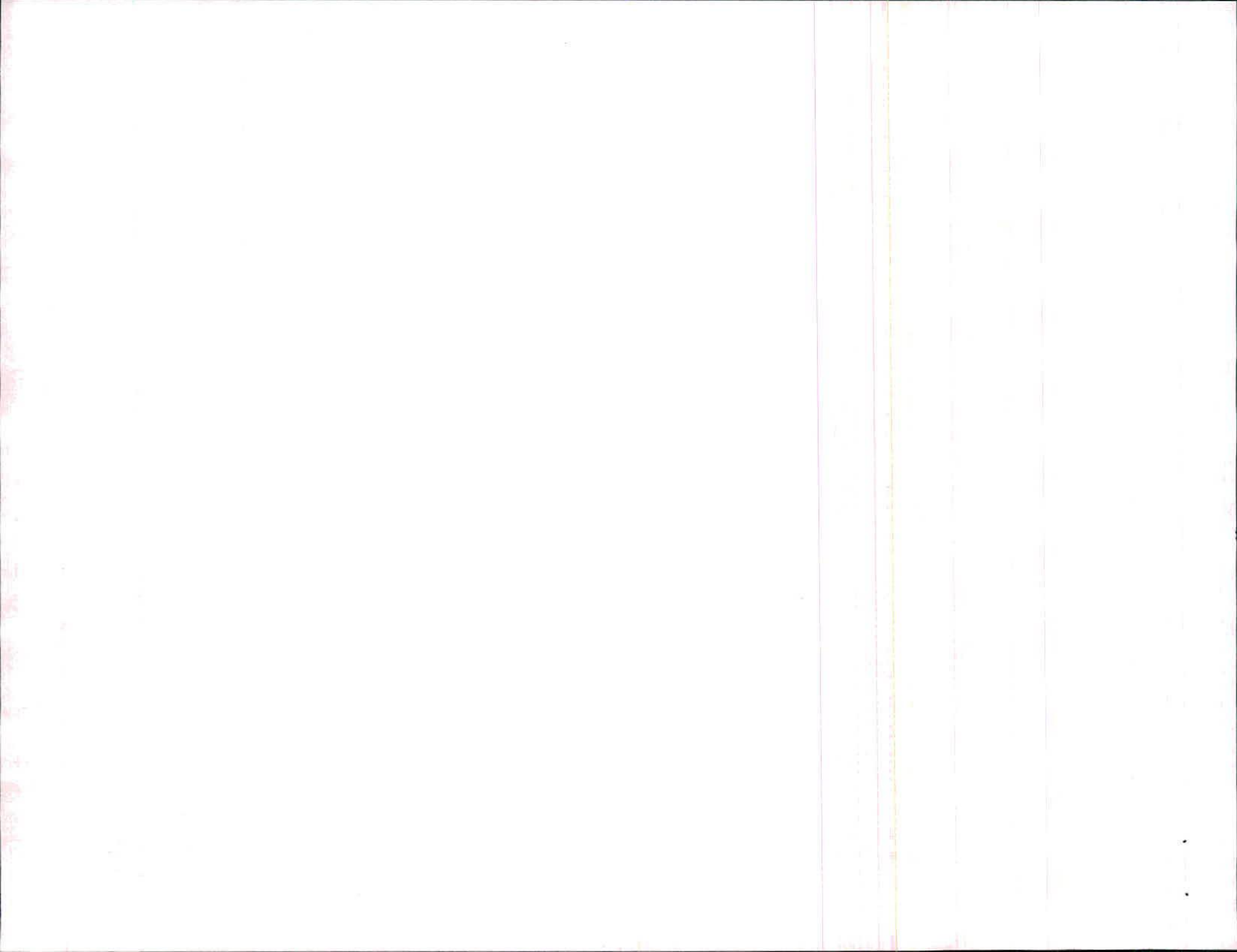
Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



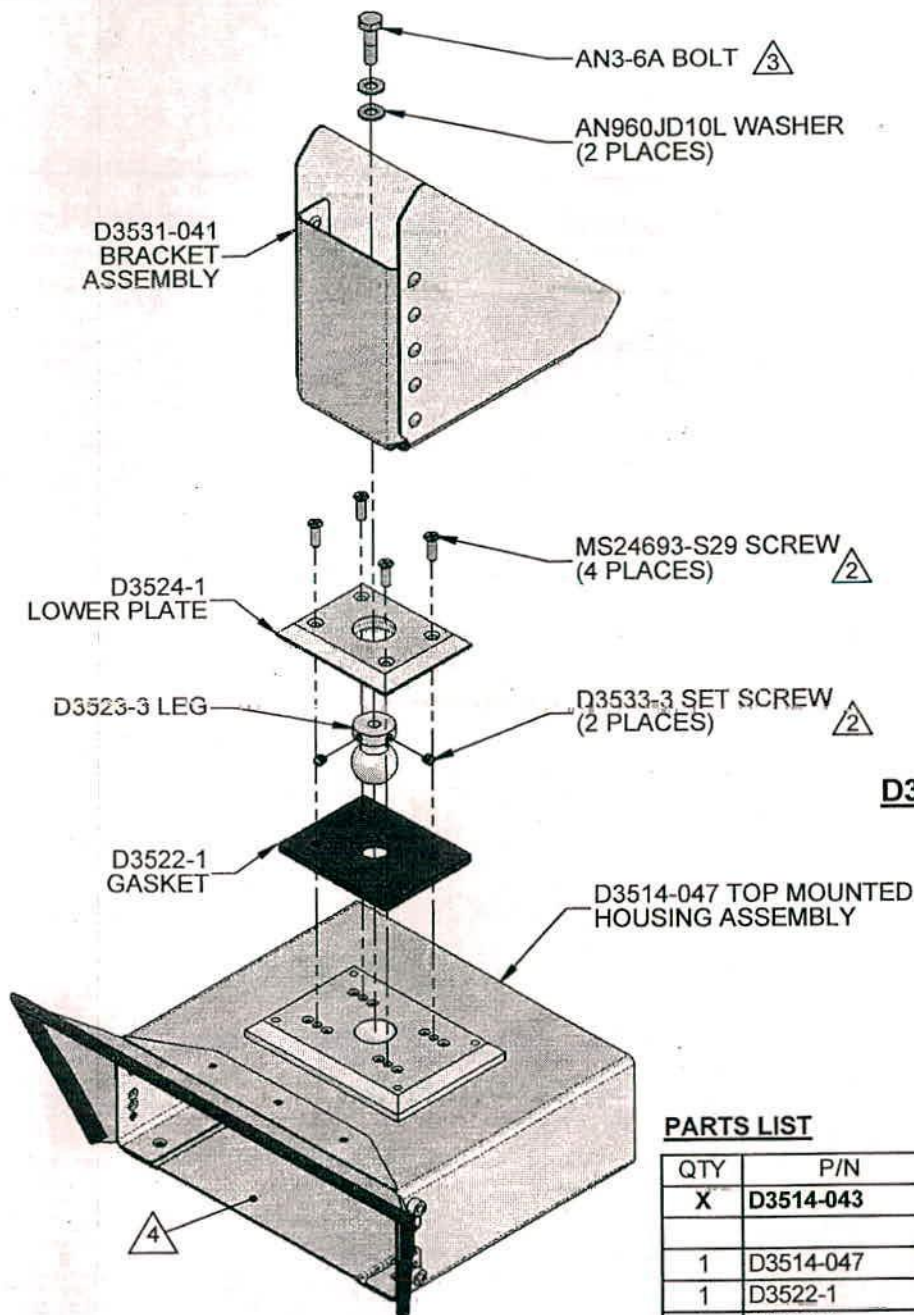
U 07-10-24

07/10/26





DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3514	REV. 1 SHEET 2 OF 2
DATE 07.06.18		TITLE GPS RECEIVER HOUSING	SCALE 1:



RELEASED
07.08.03

**D3514-043 TOP MOUNTED
GIMBAL ASSEMBLY**

PARTS LIST

QTY	P/N	DESCRIPTION
X	D3514-043	TOP MOUNTED GIMBAL ASSEMBLY
1	D3514-047	TOP MOUNTED HOUSING ASSEMBLY
1	D3522-1	GASKET
1	D3523-3	LEG
1	D3524-1	LOWER PLATE
1	D3531-041	BRACKET ASSEMBLY
2	D3533-3	SET SCREW
1	AN3-6A	BOLT
2	AN960JD10L	WASHER
4	MS24693-S29	SCREW

NOTE:

- 1) ASSEMBLE PER DART QSI 003
- 2) TORQUE SCREWS TO 5-6 in-lbs
- 3) TORQUE BOLTS TO 15-25 in-lbs
- 4) IDENTIFY WITH DART P/N "D3514-043" USING A WHITE MARKER ON THE INSIDE OF THE HOUSING ASSEMBLY WHERE INDICATED

COPYRIGHT © 2007 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

NO. _____

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

